










Date: Wednesday, 28/01/2009 5:02:06 PM
 User: Julie Dawson

Process Sheet

Customer	: CC-EUR01 Eurocopter France	Drawing Name	: LONG STEP ASSEMBLY HIGH SKID RH
Job Number	: 45345		
Estimate Number	: 13561		
P.O. Number	:	Part Number	: D350591312
This Issue	: 28/01/2009 S.O. No. :	Drawing Number	: D3272 REVB-EUROCOPTER
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: B
Previous Run	: 44451	Material	:
Written By	:	Due Date	: 20/02/2009 Qty: 10 Um: Each
Checked & Approved By	: <u>JLD 09.01.29</u>		
Comment	: Est Rev:A 04.03.22 New issue KJ/RF Est Rev:B 07-06-09 Added D3572-1 JLM Est. returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
		<u>H La JLD 09/03/09</u>	
Comment: DOCUMENT CONTROL Photocopy bluefile and type labels as per PPP D350-591-312 CHG001			
2.0	D32721	Step	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) STEP BATCH: <u>344345</u>			
3.0	D30671	End Plate	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) Pick: Qty Part Number Description Batch 1 D3067-1 End Plate <u>344330</u>			
4.0	D32191	Plate	
			
Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s) Pick: Qty Part Number Description Batch 2 D3219-1 Support <u>344568</u>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 45345

Part Number: D350591312

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod M108037
M110431

3-Grind End Plate flush

PD 09.02.28 10
PD 09.02.28 10
SAD 09-03-02 (10)

6.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09.03.02

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SAD 09/03/02 (10RH)

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 09-03-02 (10)

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SAD 09/03/03 (10)

✓ 10.0 D3065041 Step Leg Assembly Hi



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D3065-041 Step Leg Assy B4358(4) B44395(6)

SAD 09-03-03

✓ 11.0 D30661 Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D3066-1 Spacer B45396

SAD 09-03-03

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 45345

Part Number: D350591312

Job Number:



Seq. #:	Machine Or Operation:	Description :
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12.0	MS20600AD4W4	Rivets
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✓



Comment: Qty.: 16.0000 Each(s)/Unit Total : 160.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 MS20600AD4W4 Rivet M110002

SAD 09-03-03 (60)

13.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Assemble Leg Assembly as per Dwg D3272.

SAD 09-03-03 (40)

14.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S09103/03 (10) RH

15.0	D30671	End Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3067-1 End Plate 344330

BE 09/03/05

16.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Bevel Aft end for welding

2-Inspect for foreign object as per QSI 024

3-Weld Aft End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod M109213 / M110676

4-Grind End Plate flush

5-Install last rivet.

BE 09/03/05

SAD 09-03-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 45345

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-03-06

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

509103/06 (X10 RH)

19.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

BR 09-03-09 (10)

20.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 110959

START TIME:

16:00

OVEN TEMPERATURE:

320°

FINISH TIME:

16:30

UMD / BR 09-03-9 (10)

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3272 and QSI 005 4.4

M 110454

BR 09-03-10 (X10)

22.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

M-1 09/03/10 (10X)

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

24.0

D22303

Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2230-3 Mounting Lug

Bu4045

9/3/6

Sip

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 45345

Part Number: D350591312

Job Number:



Seq. #: Machine Or Operation: Description :

25.0

D2618

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2618 Bushing B42169 50

26.0

D2856400

Abraison Strip



Comment: Qty.: 0.6000 f(s)/Unit Total: 6.0000 f(s)

Abraison Strip

2 x D2856-400-720 B42437 50

27.0

D32351

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D3235-1 Mounting Lug B41342 B45398 B4631 50

28.0

D3278041

Support Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3278-041 Support Assembly B43418 B44573 50

29.0

AN335A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN3-35A Bolt M108827 M110467 50

30.0

AN413A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 80.0000 Each(s)

Bolt

batch: M110865 9/3/04 50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 45345

Part Number: D350591312

Job Number:



Seq. #:	Machine Or Operation:	Description :
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31.0	AN536A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN5-36A Bolt M110467

50

32.0	AN960JD10	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD10 Washer M110139

50

33.0	AN960JD416	Washer
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 160.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 AN960JD416 Washer M110523

50

34.0	AN960JD516	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD516 Washer M110363

50

35.0	MS21042L3	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L3 Nut (or -3) M110399

9/3/06

100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Part Number: D350591312

Job Number:



Seq. #:	Machine Or Operation:	Description :
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36.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4

Nut (or -4)

M109200

37.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L5

Nut (or -5)

M110300

9/3/10

38.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

9/3/10 10

39.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-312

Location:

Rev 5

88 09/03/10 X14

40.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/11

Job Completion



U 09/03/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>QD</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED07.06.04 *ff*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

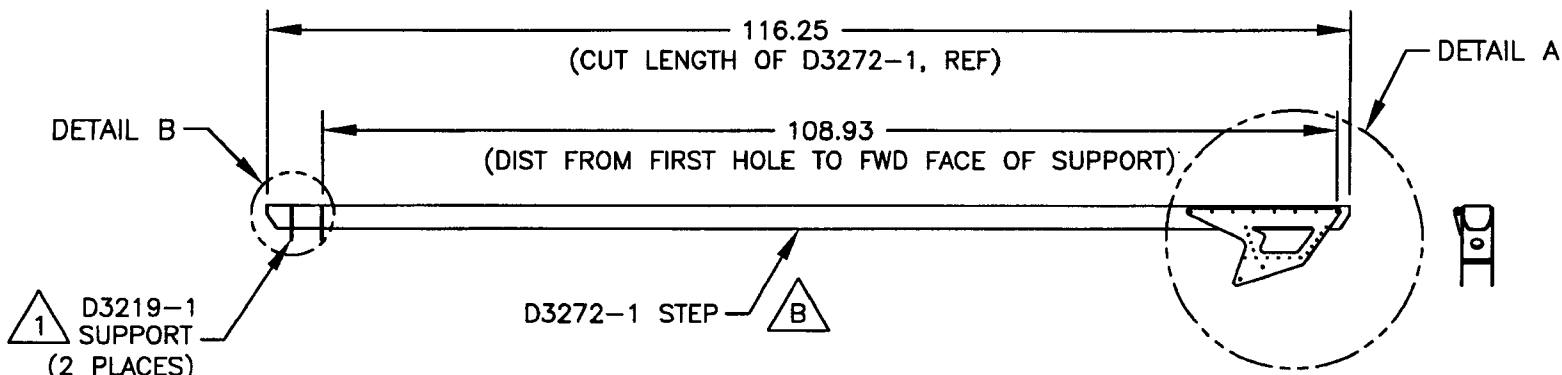
- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *45345*

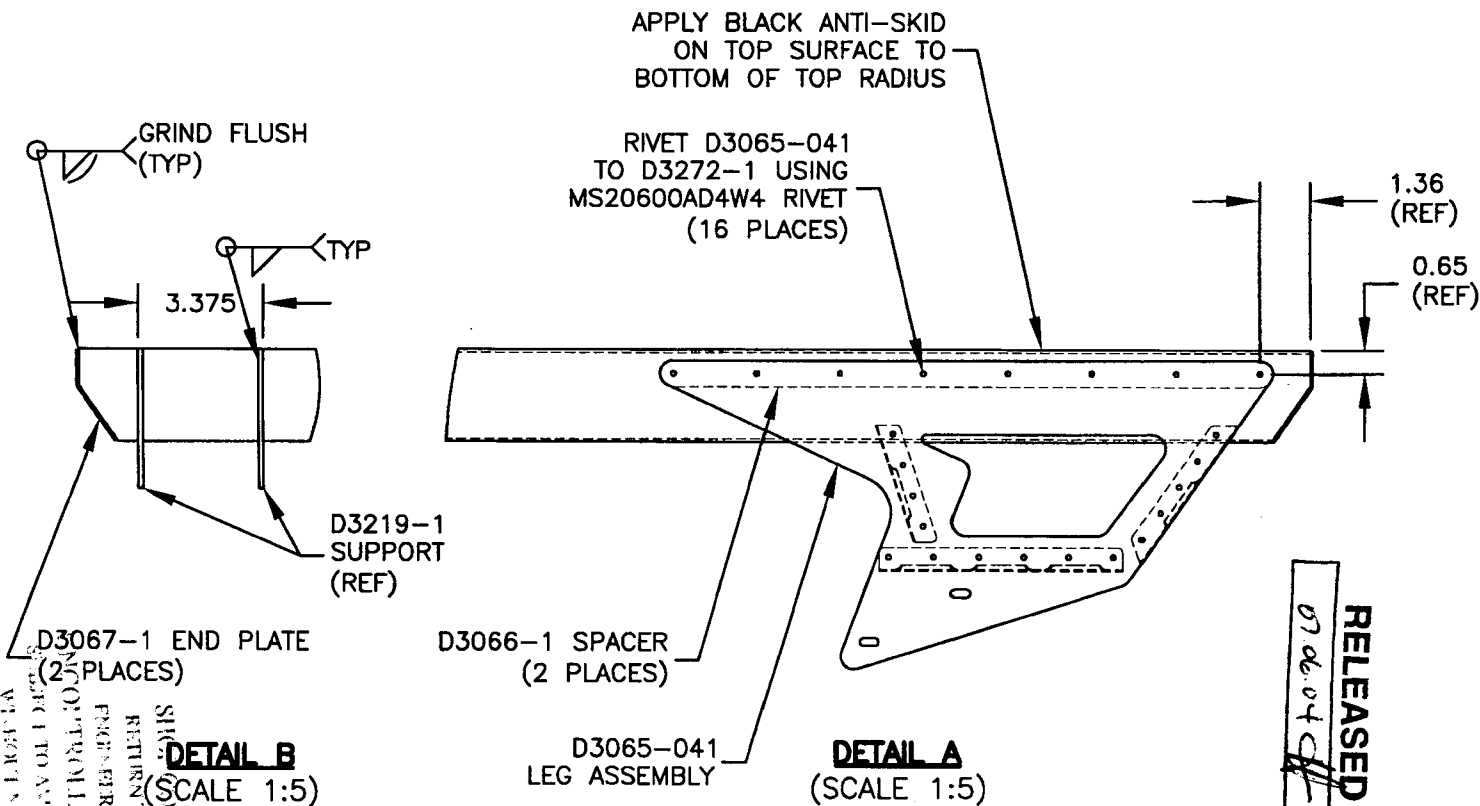
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DART



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



RELEASED
07.06.04

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. B
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	SHEET 2 OF 3
DATE	TITLE	STEP ASSEMBLY, HI LONG	SCALE
07.05.18			1:20

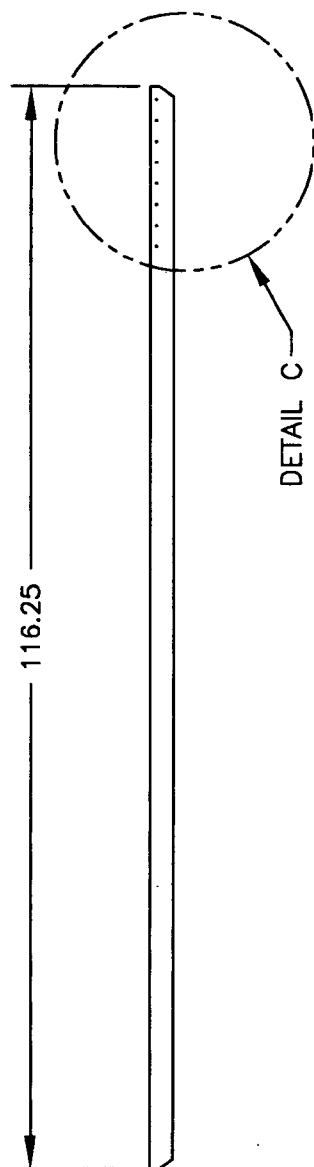
45345



DESIGN <i>GP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG		SCALE 1:20

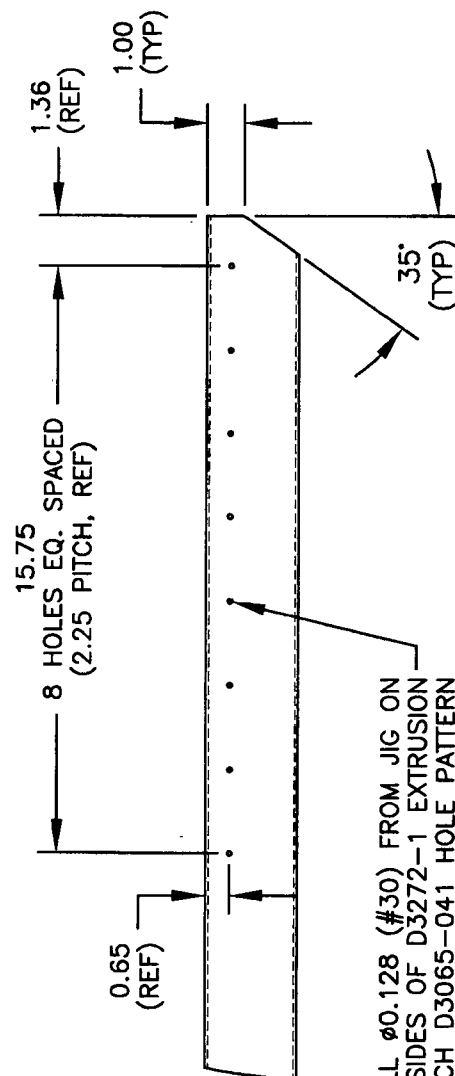
RELEASED

07.06.04 *H*



DETAIL C

B **D3272-1 STEP**
(MAKE FROM D2622-120 STEP EXTRUSION)



DETAIL C
(SCALE 1:5)

DRILL $\phi 0.128$ (#30) FROM JIG ON
BOTH SIDES OF D3272-1 EXTRUSION
TO MATCH D3065-041 HOLE PATTERN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AGREEMENT
WHERE THE
W/ *HS*
NO. *345*

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